

# Work Order ID 65634

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Page 1

Item ID: D3197-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Bar Assembly

Start Date: 1/20/11 Start Qty: 4.00

Cust Item ID:

Required Date: 2/04/11 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3197

Rev B

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 29.125" long

SL 11/03/01

④

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Face ends to length per dwg D3197-1 as per Folio FA340 and Dwg D3197-3-Debur

SL 11/03/01

④

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SL 11/03/01

4

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Cust Item ID:

Required Date: 2/04/11 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Lathe Conv Conventional Lathe	CONVENTIONAL LATHE  Memo Chamfer as per Dwg D3197	0.00  0.00		52	11/03/01	4	0		
140  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00		smk	11/03/01	4	0		
150  HandFinish Hand Finishing	Chemical Conversion Coat per QS1005 4.1  Memo	0.00  0.00		7m-d	11/03/02	(4X)			

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Setup Start



Revision ID:

Item Name: Bar Assembly

Stop



Start Date: 1/20/11 Start Qty: 4.00



Cust Item ID:

Required Date: 2/04/11 Req'd Qty: 4.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

M115128

Memo

0.00

START TIME:

320

OVEN TEMPERATURE:

FINISH TIME:

1:30

4X m-1 11/03/03

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

4 6 11/03/03

180



Small Fab

Small Fab

Small Fab

0.00

Memo

0.00

Assemble D3197-041 as per Dwg D3197

950/03/04 (4)

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Accept



Setup Start



Revision ID:

Stop



Item Name: Bar Assembly

Start Date: 1/20/11 Start Qty: 4.00



Cust Item ID:

Required Date: 2/04/11 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/103/07

(X4)

200

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

2600

11/3/7 SP (4)

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/03/08

ME

11-03-07

# Picklist Print

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Work Order ID: 65634

Parent Item: D3197-041

Parent Item Name: Bar Assembly

Start Date: 1/20/11

Required Date: 2/04/11

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev: A New Issue 05-11-08 JLM  
IPP Rev: B As per Rev B 06-03-10 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN960JD10 NAS1149D0363J Purchased



Washer

4 M116583

(240)

Location

Loc Qty

Loc Code

ST

6

107715

6

ST335

2

105792

2

D2690-5

Manufactured

No

180

Each

10.0000

2



Lanyard Assembly

Location

Loc Qty

Loc Code

ST021

10

64533

10

D3242-1

Manufactured

No

180

Each

12.0000

2



Tag

Location

Loc Qty

Loc Code

ST044

12

65390

12

D3489-3-200

Manufactured

No

180

Each

8.0000

2



PIP PIN

Location

Loc Qty

Loc Code

ST62

8

61419

1

65129

7

24  
E 5/11/03/04

8  
E 5/11/03/04  
B66820 (K)

8  
E 5/11/03/04  
B64531 (8X)

8  
E 5/11/03/04  
B67042 (502)  
3

# Picklist Print

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Work Order ID: 65634

Parent Item: D3197-041

Parent Item Name: Bar Assembly

Start Date: 1/20/11

Required Date: 2/04/11

Start Qty: 4.00

Required Qty: 4.00

M7075T73R1.000

Purchased

No

180

f

14.5500

2.42

12.1



7075-T73 Rd Bar 1.00



11/02/08

Location

Loc Qty

Loc Code

MAT

116962

14.55

115165

5

116405

3.6

116604

5.95

6.05

6.05

MS21042L3

Purchased

No

180

Each

3,115.000

2

8



11/03/04

Nut

Location

Loc Qty

Loc Code

ST300

3115

114784

9

115835

606

116391

900

116540

800

116549

800

8

MS27039-1-24

Purchased

No

100

Each

95.0000

2

8



11/03/04

Screw

Location

Loc Qty

Loc Code

ST292

95

100151

95

8

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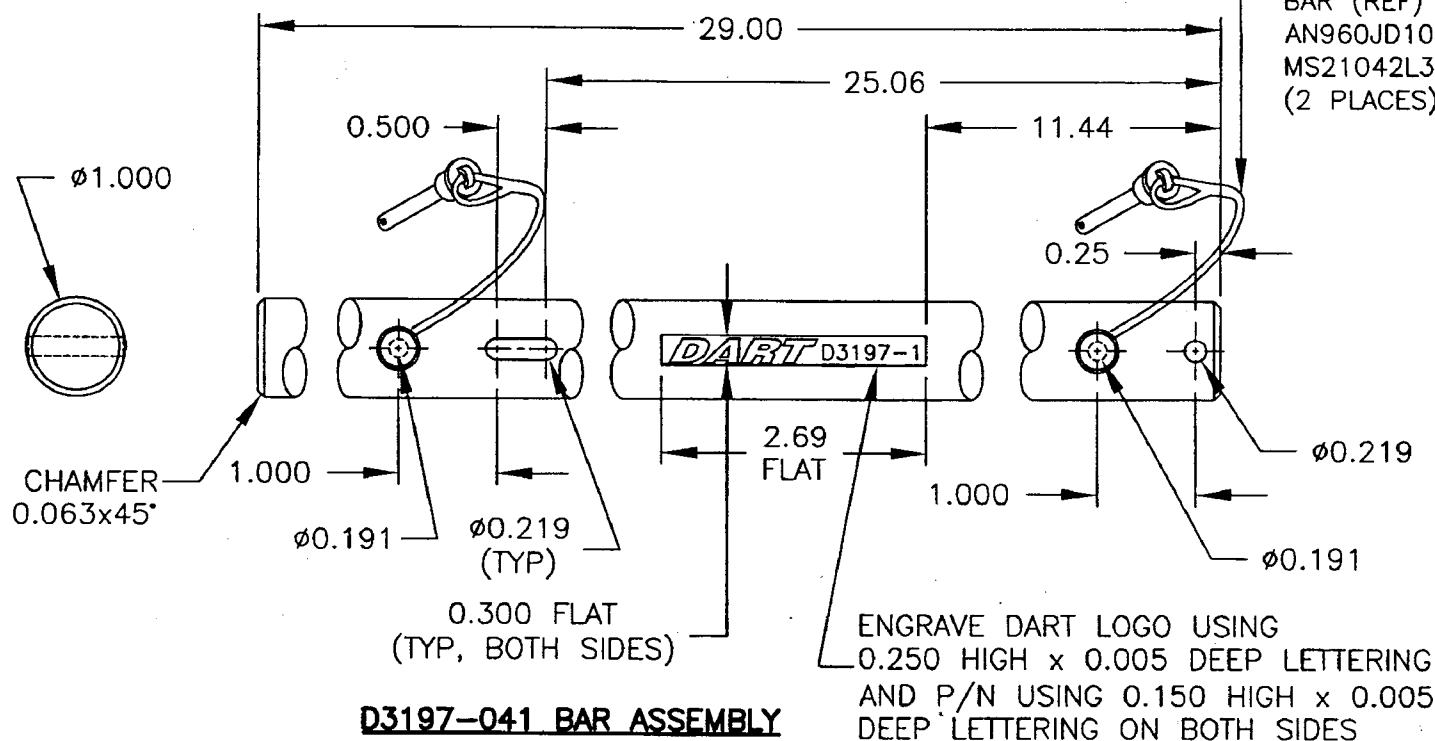
Shop Packet Print

Page 2



RELEASED

D3489-3-200 PIP PIN (1)  
D3242-1 TAG (1)  
MS27039-1-24 BOLT (1)  
AN960JD10 WASHER (1)  
D2690-5 LANYARD (1)  
AN960JD10 WASHER (1)  
BAR (REF)  
AN960JD10 WASHER (1)  
MS21042L3 NUT (1)  
(2 PLACES)



**D3197-041 BAR ASSEMBLY**

**D3197-1 BAR**

- 1) MATERIAL: 7075-T73 ROUND BAR (QQ-A-200/11 or QQ-A-225/9)  $\phi$ 1.000 O.D. (REF DART SPEC. M7075T73R1.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) FOR TOOLING, IT IS ACCEPTABLE TO HAVE A 0.06 DEEP x 60° CENTER MARK AT EITHER END OF THE BAR

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	06.01.10	TITLE	BAR	REV. B
		DRAWING NO.	D3197	SHEET 1 OF 1
		SCALE	1:1	
	A	03.07.01	NEW ISSUE	
	B	06.01.10	CHG PIP PIN; ADD D3242-1 TAG	

